

Work Order ID 84639

84639

Page 1

May-17-12 11:52:37 AM

Item ID: D350-689-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Dual High Back Seat Ass'y

Start Date: 17/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MCJ

Date: 12/05/12 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D350-689

B

100

0.00

100

Large Fab

Brake NC

Memo

0.00

Brake NC

1-Bend D3023-1 form edge of back pan as per dwg D3023 using D3017-041
back frame
2- Bend D3022-1 as per dwg

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

8/12/10

①

B 12-7-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Dual High Back Seat Ass'y

Stop ***NS2***

Start Date: 17/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

114		0.00							
114									
Large Fab	Memo	0.00							
Large Fab	1- Transfer drill Seat Pan From Frame ***Transfer drill in D3022-1 using D3017-041***								
	2- Deburr								
	3- Assemble as per IIN 350-689-041								

① 12-7-10
EP 12/07/10

116	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

116									
QC	Memo	0.00							
Quality Control									

5/12/10

117	Chemical Conversion Coat per QSI005 4.1	0.00							
-----	---	------	--	--	--	--	--	--	--

117									
HandFinish	Memo	0.00							
Hand Finishing	Chemical Conversion Coat only D3023-1 and D3022-1								

1 NG 12-7-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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N900040100

Setup Start

NS1

Revision ID:

Item Name: Dual High Back Seat Ass'y

Stop

NS2

Start Date: 17/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

120

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

130

QC3- Inspect Part Finish

0.00

130

QC

Quality Control

Memo

0.00

140

Large Fab

0.00

140

Large Fab

Large Fab

Memo

Assemble as per Dwg IIN-D350-689

0.00

W121279

11:00
32001
11:30

IX

M.F.
12/07/10

10

BL 127-10

IX

ES
12/07/11

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Dual High Back Seat Ass'y

Start Date: 17/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location:

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

W120720

MLJ 12/07/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

May-17-12 11:52:41 AM

Page 1

Work Order ID: 84639

84639

Parent Item: D350-689-041

D350-689-041

Parent Item Name: Dual High Back Seat Assy

Start Date: 1/7/05/2012

Required Date: 31/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:H Removed Sub-Parts 06-02-09 JLM

IPP Rev:I As per NCR 070 06-09-06 JLM

per DSI 9498 DD 10.02.12 verified by:JLM

IPP Rev:J as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3022-1 Manufactured No

No

100

Each

4.0000

1

1

**

EL 12-7-12

D3022-1

Seat Pan

Location

Loc Qty

Loc Code

WA

4

82235

4

D3023-1 Manufactured No

No

100

Each

1.0000

1

1

**

EL 12-7-12

D3023-1

Back Panel

Location

Loc Qty

Loc Code

WA

1

82234 x 1 79302

1

D3016-041 Manufactured No

No

114

Each

0.0000

1

1

**

EL 12-7-12

D3016-041

Seat Frame Assembly

86089 x 1

D3017-041 Manufactured No

No

114

Each

0.0000

1

1

**

EL 12-7-12

D3017-041

Back Frame Assembly

86090 x 1

AN3-12A Purchased No

No

140

Each

22.0000

3

3

**

EL 12/07/11

AN3-12A

Bolt

Location

Loc Qty

Loc Code

ST351

22

114536

1

119641

21

M121825

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D350-689-041

D350-689-041

Parent Item Name: Dual High Back Seat Ass'y

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 1.00

Required Qty: 1.00

~~AN960JD10L~~

NAS1149D0332J

Purchased

No

140

Each

0.0000

17

17

***AN960.ID10I ***

Washer

D3021-041

Manufactured

No

140

Each

0.0000

1

D3021-041

Tube Assembly

D3024-1

Manufactured

No

140

Each

10.0000

3

3

D3024-1

Spacer

Location

Loc Qty

Loc Code

ST023

10

77074

10

D3028-1

Manufactured

No

140

Each

10.0000

4

4

D3028-1

Stud

Location

Loc Qty

Loc Code

ST024

10

72238

10

D3029-1

Manufactured

No

140

Each

8.0000

2

2

D3029-1

Spring

Location

Loc Qty

Loc Code

GA

8

68607

8

D3030-1

Manufactured

No

140

Each

8.0000

2

2

D3030-1

Lock

Location

Loc Qty

Loc Code

ST024

8

73516

8

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Qty	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

Work Order ID: 84639

Parent Item: D350-689-041

Parent Item Name: Dual High Back Seat Ass'y

84639

D350-689-041

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3031-1 Manufactured No

140 Each 15.0000 2 2

D3031-1

Loop

**

Location

Loc Qty

Loc Code

GA

15

70016

7

79747

8

MS20600-AD4W2 Purchased No

140 Each 273.0000 40 40

MS20600-AD4W2

Rivet

**

Location

Loc Qty

Loc Code

ST321

273

116391

5

116471

4

116805

4

117601

1

117885

10

119638

3

120142

146

121011

100

MS20600-AD4W3 Purchased No

140 Each 904.0000 6 6

MS20600-AD4W3

Cherry Rivets

**

Location

Loc Qty

Loc Code

ST321

771

111636

36

117601

3

118626

474

120308

258

WA018

133

107939

133

May-17-12 11:52:41 AM

Shop Packet Print

Page 3

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Page 4

Work Order ID: 84639

Parent Item: D350-689-041

Parent Item Name: Dual High Back Seat Ass'y

84639

D350-689-041

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

140

Each

2,556.000

17

17

MS21042I 3

Nut

**

EP 12/07/11

Location

Loc Qty

Loc Code

ST300

2556

117885

32

119017

1094

119075

138

121349

359

121444

933

17

MS21042L4

Purchased

No

140

Each

4,686.000

6

6

MS21042I 4

Nut

**

EP 12/07/11

Location

Loc Qty

Loc Code

ST300

4686

119075

153

121011

1270

121444

2963

121652

300

6

MS24693-S272

Purchased

No

140

Each

313.0000

4

4

MS24693-S272

Screw

**

EP 12/07/11

Location

Loc Qty

Loc Code

GA

296

118352

296

ST288

17

116391

11

116737

2

117977

4

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 84639

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Parent Item: D350-689-041

D350-689-041

Parent Item Name: Dual High Back Seat Ass'y

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-17

Purchased

No

140

Each

119.0000

4

4

MS27039-1-17

Screw

**

EB 12/07/11

Location

Loc Qty

Loc Code

GA

100

120142

100

4

ST291

19

117591

19

MS27039-1-19

Purchased

No

140

Each

36.0000

6

6

MS27039-1-19

Screw

**

EB 12/07/11

Location

Loc Qty

Loc Code

ST292

36

112794

36

6

MS27039-4-21

Purchased

No

140

Each

33.0000

6

6

MS27039-4-21

Screw

**

EB 12/07/11

Location

Loc Qty

Loc Code

ST292

33

114055

1

117977

4

118429

28

6

NAS1149D0432J

Purchased

No

140

Each

171.0000

6

6

NAS1149D0432.I

WASHER

**

EB 12/07/11

Location

Loc Qty

Loc Code

ST298

171

116583

127

116584

44

6

May-17-12 11:52:42 AM

Shop Packet Print

Page 5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

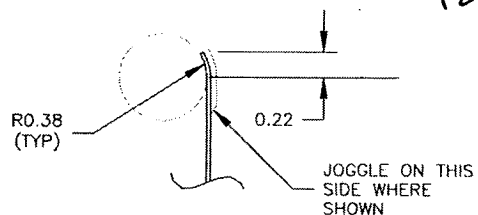
NO. 04639 MW

12/05/22

SECTION A-A

SCALE 1:1

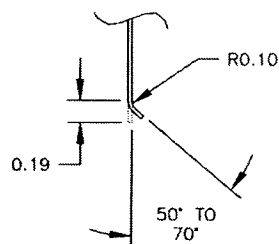
(TYPICAL, EXCEPT WHERE SHOWN)



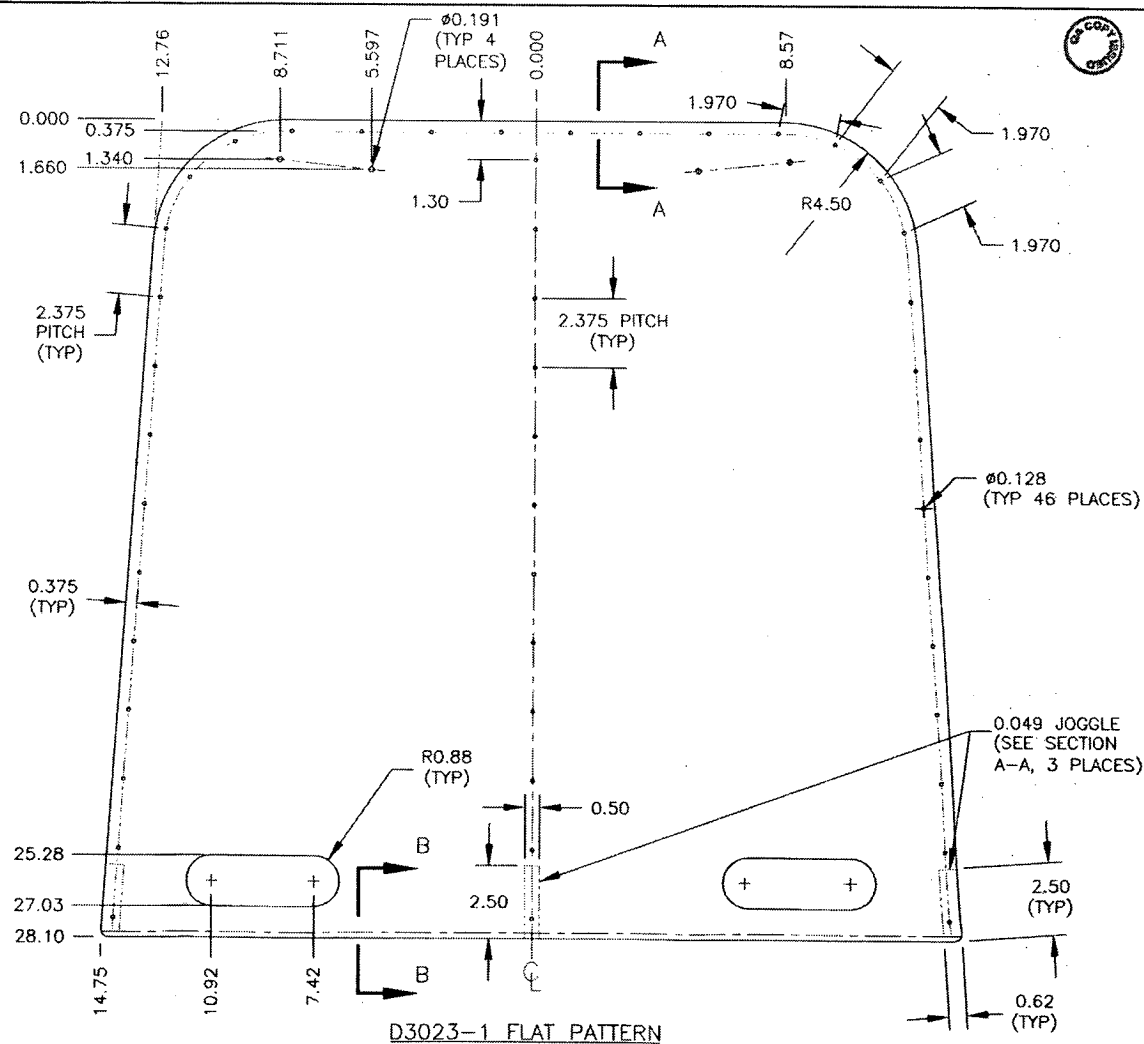
SECTION B-B

SCALE 1:1

(BOTTOM EDGE ONLY)

RELEASED
01.06.07

D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

A	01.05.18	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	CP	APPROVED
DATE	01.05.18	TITLE
		BACK PANEL
		DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
		DRAWING NO. D3023
		REV. A
		SHEET 1 OF 1
		SCALE 1:4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

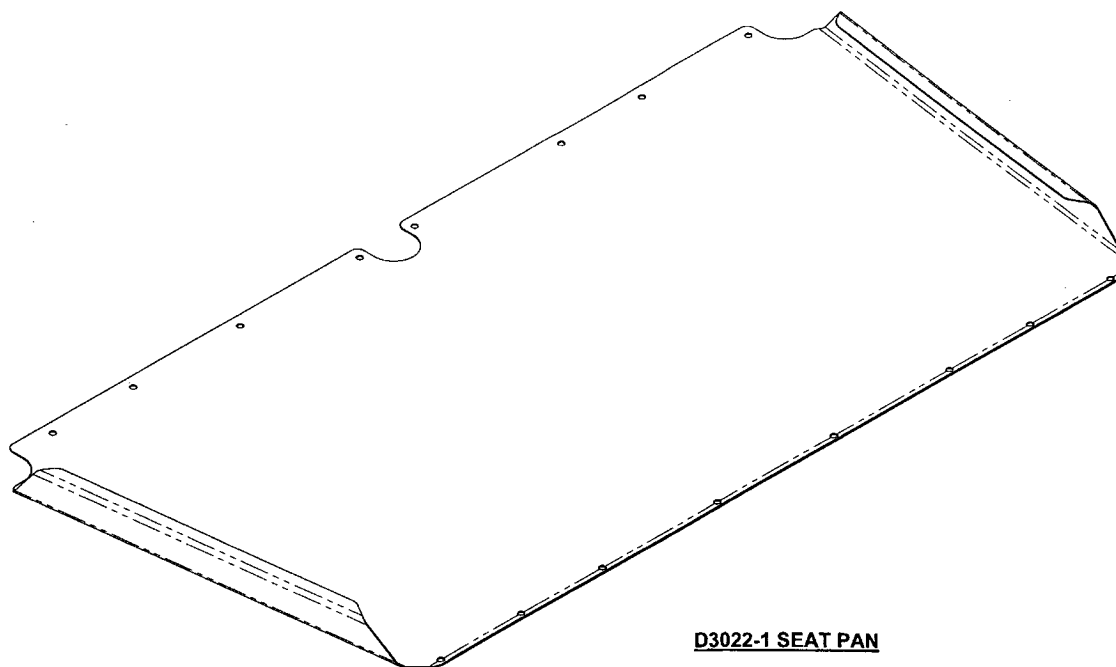
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04639



D3022-1 SEAT PAN

RELEASED
08/12/15

B		REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. SPLIT VIEWS FOR FORMED PART AND FLAT PATTERN. B7-2 7" DIM ADDED, D7-3 12.075 WAS 12.325, D6-3 9.175 WAS 9.425 & D5-3 5.300 WAS 5.550. REASON: DRAFTING ERROR.		AJS	08.11.27
A		NEW ISSUE		CP	01.05.18
REV.	DESCRIPTION			BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3022 REV. B SHEET 1 OF 3 TITLE SEAT PAN SCALE NTS COPYRIGHT © 2001 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>			
DRAWN	AJS				
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.					
DATE	08.11.27				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

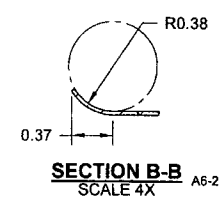
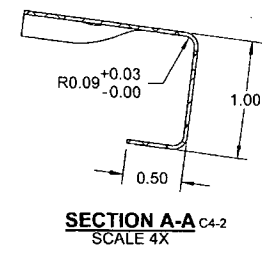
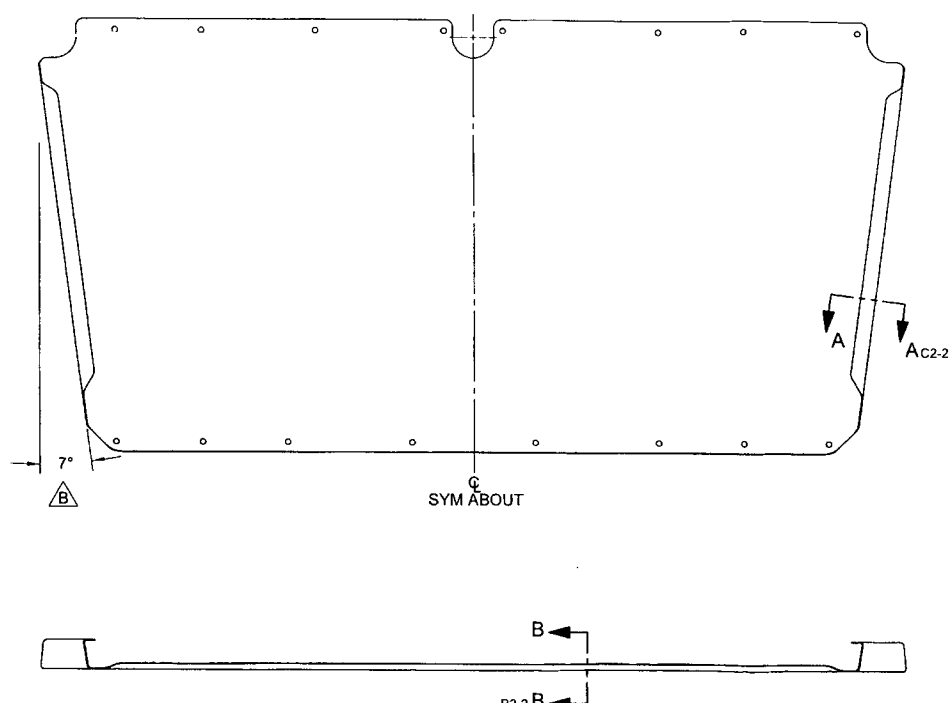
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NOTE: Date & initial all entries

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D3022-1 SEAT PAN

RELEASED
08/12/15

- NOTES:**
- 1) MATERIAL: MAKE FROM D3022-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3022-1" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.36 lbs

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3022	REV. B
MFG. APPR.		TITLE SEAT PAN	SHEET 2 OF 3
APPROVED		SCALE NTS	
DE APPR.		COPYRIGHT © 2001 BY DART AEROSPACE LTD	
DATE	08.11.27	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

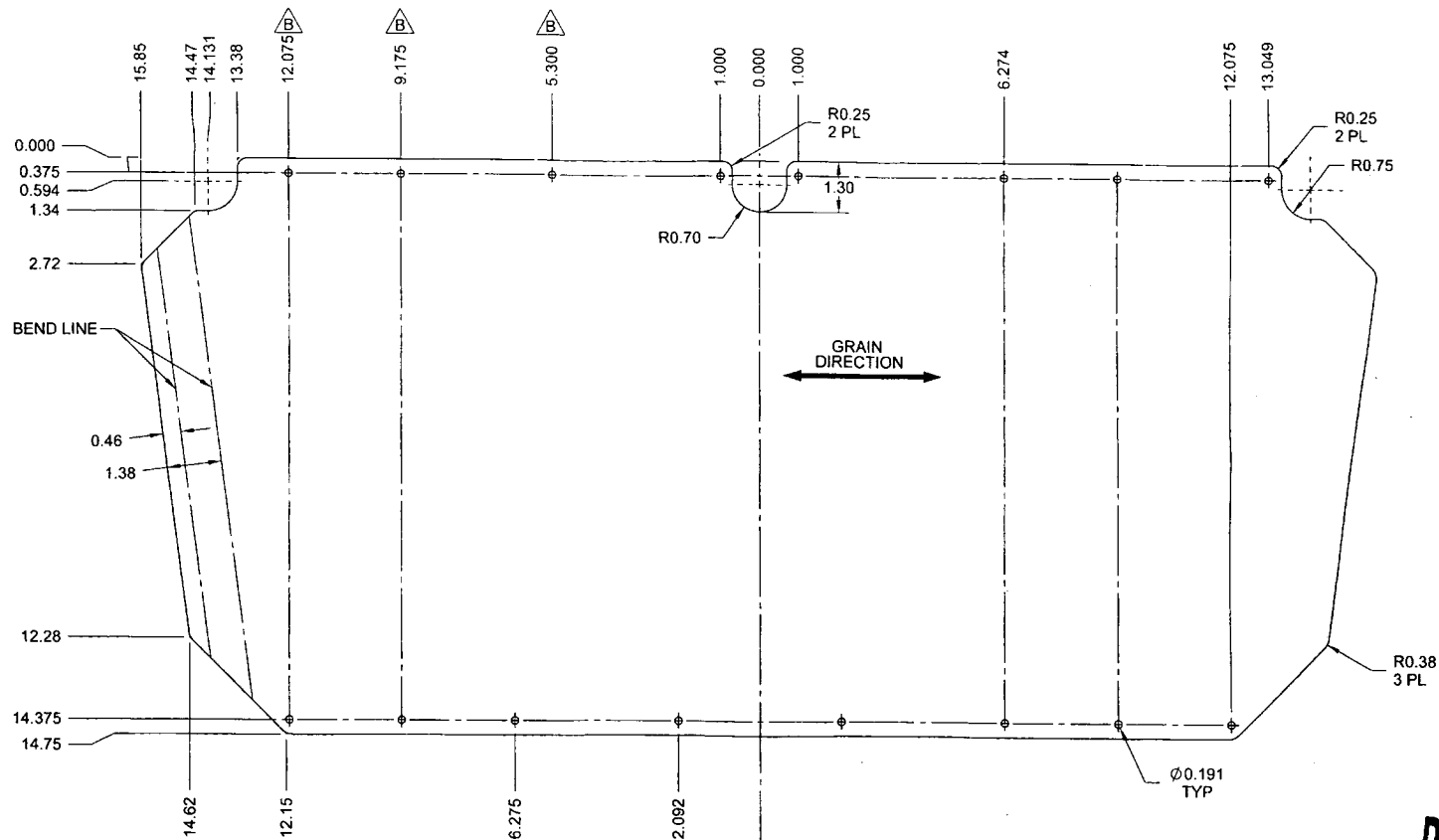
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



84639

RELEASED
28/12/15 JAW

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
REF DART SPEC M2024T3S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.36 lbs

D3022-1F SEAT PAN

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3022	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT PAN	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

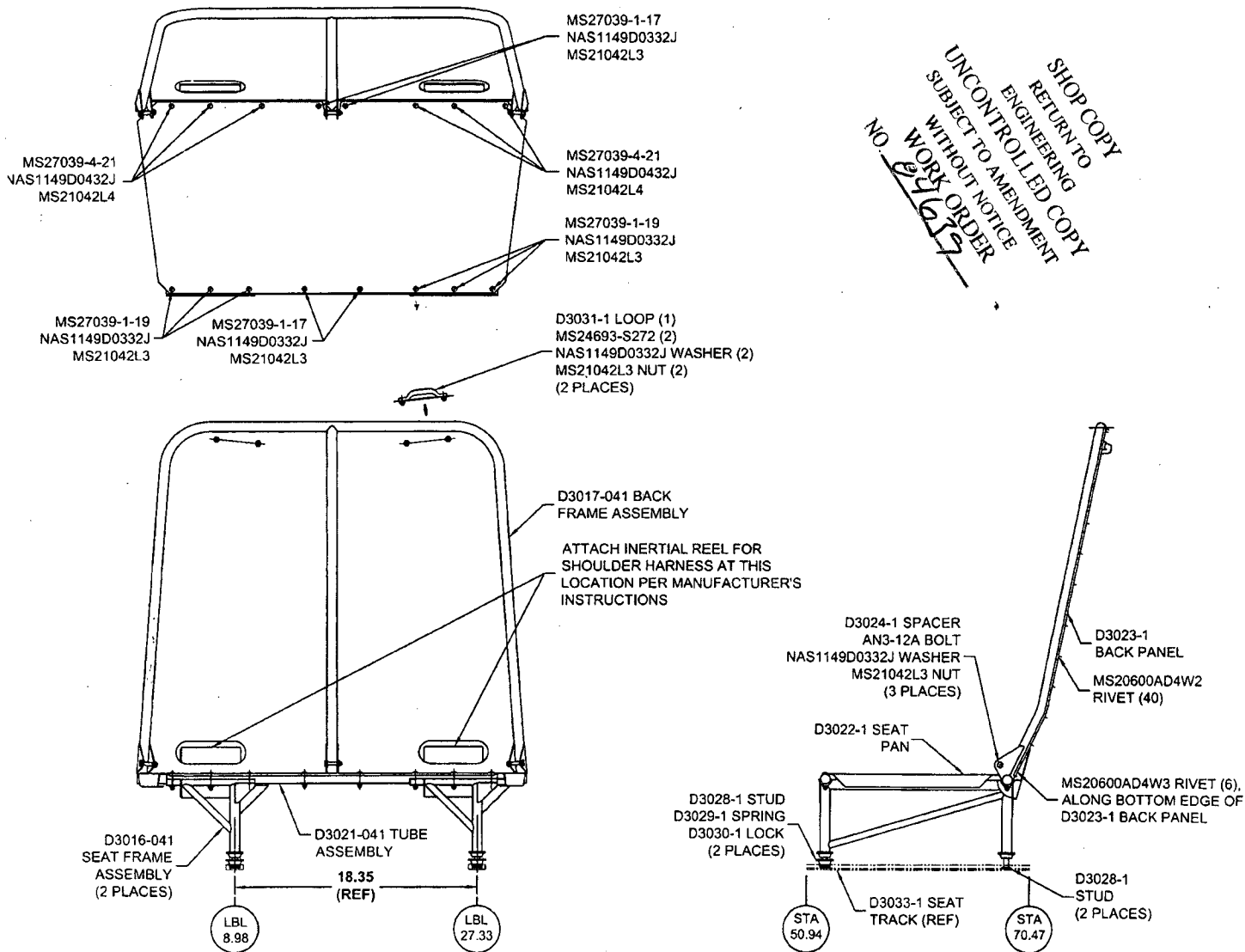


FIGURE 9: Installation of D350-689-041 Dual High Back Seat Assembly

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Revision: B
Date: 11.07.22

